

Work Order ID 160680

Tuesday, May 02, 2017 3:34:26 PM

160680

Page 1

Item ID: D2704 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Cross Brace
 Start Date: 5/4/2017 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 5/10/2017 Req'd Qty: 2.00 ***2*** Customer:
 Reference: SCHEDULED/S

Approvals: Process Plan: DAS 21 Date: MAY 03 2017 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: 9-89 Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2704	Rev A1 ✓								
100	NC BRAKE	0.00			DAS 30 9-89	<u>2</u>			JUN 08 2017
100									
Brake NC	Memo	0.57							
Brake NC	Punch tube 304/316 with 2B finish Debur								
110	QC5- Inspect part completeness to step on W/O	0.00				<u>2</u>			JUN 08 2017
110									
QC	Memo	0.04							
Quality Control									
120	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel	0.00				<u>2</u>	<u>φ 17068</u>		JUN 08 2017
120									
Powdercoat	Memo	0.20							
Powder Coating	START TIME: <u>8:30</u> FINISH TIME: <u>4:00</u> OVEN TEMPERATURE: <u>400</u>								

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER : _____							

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130 *130* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.02				<u>+2</u>			DAS 16 9-89 17/06/08
140 *140* Packaging Packaging	Identify as per dwg & Stock Location: <u>5B60</u> Memo	0.00 0.02				<u>2</u>			DAS 6 9-89 JUN 14 2017
150 *150* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.20							17/6/13 <u>28</u> DAS 21 9-89 JUN 12 2017

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Picklist Print

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Parent Item: D2704

D2704

Parent Item Name: Cross Brace

Start Date: 5/4/2017

Required Date: 5/10/2017

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP D02.04.15Added dwg Rev.A1NG

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.500W.035		Purchased	No			100	f	86.4928	2.35	4.947368			

M304TR0 500W 0.35

304 RD Tube .500 x .035W

**

DAS
30
9-89

JUN 08 2017

Location

GA

Loc Qty

86.492796

m137086

24.165477

m137199

2.300579

m137286

0.02674

m137415

60

Loc Code

137023 4.95

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